

Date: Thursday, 12/14/2006 1:57:18 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SKIDTUBE
Job Number	: 29959		
Estimate Number	: 11545		
P.O. Number	: <i>N/A</i>	Part Number	: D204635011
This Issue	: 12/14/2006 S.O. No. : <i>N/A</i>	Drawing Number	: N/A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <i>N/A</i> Type : LANDING GEAR	Drawing Revision	: N/A
Previous Run	: 29958	Material	: <i>N/A</i>
Written By	: _____	Due Date	: 1/15/2007
Checked & Approved By	: <i>OK 12/14</i>	Qty:	1 Um: Each
Comment	: Est Rev: 02.08.28 Removed QC5 KJ		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy bluefile and Type labels as per PPP D204-635-011 CHG004

*07.01.12*

2.0	29959A	SKIDTUBE
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Comment: Sub-Component Pick:

Qty	Part Number	Description	Batch
1	D204-635-041	Skidtube Assembly	<i>B29959A</i>

3.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

4.0	K10003	D205-634-011 Saddle Kit
-----	--------	-------------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	K10003	Saddle Kit	<i>B29615</i>

*EB 04/01/12*

5.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
-----	-----	------------------------------------



Comment: INSPECT 100% KITS FOR COMPLETENESS

*07/01/12*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: 29 Date: 07/01/15

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

Date: Thursday, 12/14/2006 1:57:19 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKIDTUBE

Job Number: 29959

Part Number: D204635011

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D204-635-011

Location: \_\_\_\_\_

PPP Rev: 5

*Handwritten signature and date: 07/01/15*

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*Handwritten signature and date: 07/01/15*

Job Completion



*Handwritten signature and date: 07.01.15*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 12/14/2006 1:57:42 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SKIDTUBE  
 Job Number : 29959A  
 Estimate Number : 11546  
 P.O. Number : N/A  
 This Issue : 12/14/2006 S.O. No. : N/A  
 Prsht Rev. : NC  
 First Issue : N/A Type : LANDING GEAR  
 Previous Run : 29958A  
 Part Number : D204635041  
 Drawing Number : D2590 REV C  
 Project Number : N/A  
 Drawing Revision : C  
 Material : N/A  
 Due Date : 1/15/2007 Qty: 1 Um: Each  
 Written By : JA 061214  
 Checked & Approved By : JA 061214  
 Comment : Est Rev: 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 D25001190 Ext'n -1 Beam Tube 4"



Comment: Qty.: 1.0400 Each(s)/Unit Total : 1.0400 Each(s)

Pick:

Qty Part Number Description Batch  
 1 D2500-1-190 Skid Tube Extrusion B24669 Pm 06-12-14 (1)

2.0 D2597 204 Web



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch  
 1 D2597 204 Web 29961 JD 06-12-14 (1)

3.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1- Inspect mat'l. D2500-1-190 for damage Pm 06-12-14 (1)

2- Cut D2500-1-190 per Dwg D2590 .Deburr ends Pm 06-12-14 (1)

3-Drill pilot holes using drill jig DT 8149 & DT8711-1&2 Pm 06-12-14 (1)

4-Acid etch and Alodine tube per QSI 005 4.1 DP/JP 1 06-12-14 (1)

5-Open holes to 0.500" as per Dwg D2590 without cutting fluid Pm 06-12-15 (1)

6-Countersink holes as per Dwg D2590 without cutting fluid Pm 06-12-18 (1)

7-Deburr and blow out all chips from inside of tube Pm 06-12-18 (1)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: 20 Date: 07/01/15  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				
06-12-14	30	1KD2600-1-190 WAS cut short. cut to 128.5 → should be 169.5. Human error.	J	I.D. short tube use for a Tri-beam mid tube. Replace.	Pmc 06-12-14		06-12-14	2	06-12-14

NOTE: Date & initial all entries

Date: Thursday, 12/14/2006 1:57:42 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKIDTUBE\*

Job Number: 29959A

Part Number: D204635041

Job Number:



Seq. #:

Machine Or Operation:

Description :

8-Bond web in place per QSI 015. Allow 12 Hrs. cure time before cutting

Pick:

Qty	Part Number	Description	Batch
A/R	Sikaflex-291	M 102107	

Sikaflex expire date: 07-02-01

Start Time: 205

Fin Time: 205 am 06-12-19

IT/56 06-12-18 (1)

4.0

BENDING

BENDING MACHINE



Comment: BENDING MACHINE

Bend as per program D2590.C on CNC Bender

IT 06-12-21 (1)

5.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Cut tubes as per Dwg. D2590.

IT 06-12-21 (1)

2-Deburr ends after cutting. Remove alodine from around holes

Pr 06-12-21 (1)

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

BE 06-12-21

7.0

D25763

Step (Machining Detail)



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2576-3	Step	B 29486

BE 06-12-21

8.0

D2579

Crossbolt Spacer



Comment: Qty.: 17.0000 Each(s)/Unit Total: 17.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
17	D2579	Spacers	B 29603

BE 06-12-21

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action		Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng				

NOTE: Date & initial all entries



Date: Thursday, 12/14/2006 1:57:42 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKIDTUBE

Job Number: 29959A

Part Number: D204635041

Job Number:



Seq. #:

Machine Or Operation:

Description:

9.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

- 1-Prepare tube for welding D2576-3 Step Remove alodine as required. *BE 06-12-21*
- 2-Weld step D2576 as per Dwg. D2590 and QSI 004  
A/R Aluminum Rod *M101446 BE 06-12-21*
- 3-Weld crossbolt spacers D2579 as per Dwg. D2590 and QSI 004. For D2579 spacers, weld one side, pass 3/8" drill, weld other side, pass 3/8" drill  
A/R Aluminum Rod *M101446 BE 06-12-21*
- 4-Grind welds as per Dwg D2590 Grind flush ridge made from bending *Pm 06-12-22 ①*
- 5-Drill holes for wearplates using DT 8218 Open holes to 19/64", adjust stopper not to hit cross tubes. Deburr *Pm 06-12-22 ①*
- 6-Counterbore crossbolt spacers to 7/16" ID x 1.0" deep as per Dwg D2590. Deburr holes *Pm 07-01-02 ①*
- 7-Drill pilot holes for aft cap using DT 8215 Open holes to #6 Drill bit. Deburr *Pm 07-01-02 ①*
- 8-Drill pilot holes for Tow ring using DT8091, open to .640" and Deburr *Pm 07-01-02 ①*

10.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

*AD 07/01/03 ①*

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*AD 07/01/03 ①*

12.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Powder Coat White (Ref: 4.3.5.2) as per QSI 005 4.3

*M1023a1*

*M-R / YL 07/01/08*

13.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*AM 07/01/09 ①*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 12/14/2006 1:57:42 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKIDTUBE

Job Number: 29959A

Part Number: D204635041

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

D25771

Wearplate Fwd



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2577-1	Wearplate	29488

15.0

D25773

Wearplate Aft



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2577-3	Wearplate	29326

16.0

D25777

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2577-7	Wearplate	<del>29637</del> 21607

17.0

D25941

Plug



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
10	D2594-1	Plug	29621

18.0

D25943

O-Ring



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
10	<del>D2594-1</del>	<del>Plug</del>	<del>27168</del>

YL 07/01/09

02594-3 o-ring

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

Date: Thursday, 12/14/2006 1:57:42 PM  
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## Process Sheet

Customer: 00-DAR001 Dart Helicopters Services

Drawing Name: SKIDTUBE

Job Number: 29959A

Part Number: D204635041

Job Number:



Seq. #:

Machine Or Operation:

Description:

19.0

D2855

Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)  
Cap 26351

20.0

ALS71032130

Insert



Comment: Qty.: 38.0000 Each(s)/Unit Total: 38.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
38	ALS7-1032-130	Inserts	102475

21.0

AN960JD10L

Washer



Comment: Qty.: 40.0000 Each(s)/Unit Total: 40.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
8	AN960JD10L	<del>Inserts</del> Washer	102477

22.0

AN34A

Bolt



Comment: Qty.: 38.0000 Each(s)/Unit Total: 38.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
38	AN3-4A	Bolt	102832

23.0

AN35A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Bolt

15205

yl 06/07/09

24.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Install inserts & wearplates as per Dwg. D2590. Use a drop of Sikaflex on insert holes before installing wearplates

A/R Sikaflex-291 102672

Sikaflex expire date: 02/07

yl 07/01/09

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☒ DQA: ☒ Date: 07/01/15

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

Date: Thursday, 12/14/2006 1:57:43 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKIDTUBE

Job Number: 29959A

Part Number: D204635041

Job Number:



Seq. #:

Machine Or Operation:

Description :

2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580

3-Inspect for foreign object per QSI 024

4-Install 2855 Aft Cap as per Dwg D2590 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive

A/R Sikaflex-291

Sikaflex expire date: 02/07

5-Wing Walk as per Dwg D2590 and QSI 005 4.4

Batch:

1183004 25ml 07 01 10

①

25.0

QC5

INSPECT WORK TO CURRENT STEP



ml 07 01 10



①

Comment: Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

26.0

QC21

FINAL INSPECTION/W/O RELEASE



①

Comment: FINAL INSPECTION/W/O RELEASE

07/01/15

Job Completion



W 07 01 15

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries





DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2590	REV. C SHEET 1 OF 2
DATE 98.08.28		TITLE 204 SKIDTUBE ASSEMBLY	SCALE NTS
A	96.09.16	NEW ISSUE	
B	96.12.02	AS MANUFACTURED	
C	98.08.28	REDRAWN, INCLUDED DEO 9094/9097	

RELEASED  
98/09/11 DS

QTY	Part Number	Description
X	D2590-041	SKIDTUBE ASSEMBLY
*	D2500-1	EXTRUSION
1	D2597	204 WEB
1	D2575	AFT CAP
1	D2576-3	STEP
17	D2579	CROSS BOLT SPACER
10	D2594-1	PLUG
10	D2594-3	O-RING
1	D2577-1	WEARSHOE
1	D2577-3	WEARSHOE
1	D2577-7	WEARSHOE
38	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or ALS4-1032-130	INSERT
40	AN3-4A	BOLT
40	AN960JD10L	WASHER

# 08.08.28  
P 08.08.28

DEOS	
EFFECTIVE	9124 98/12/14

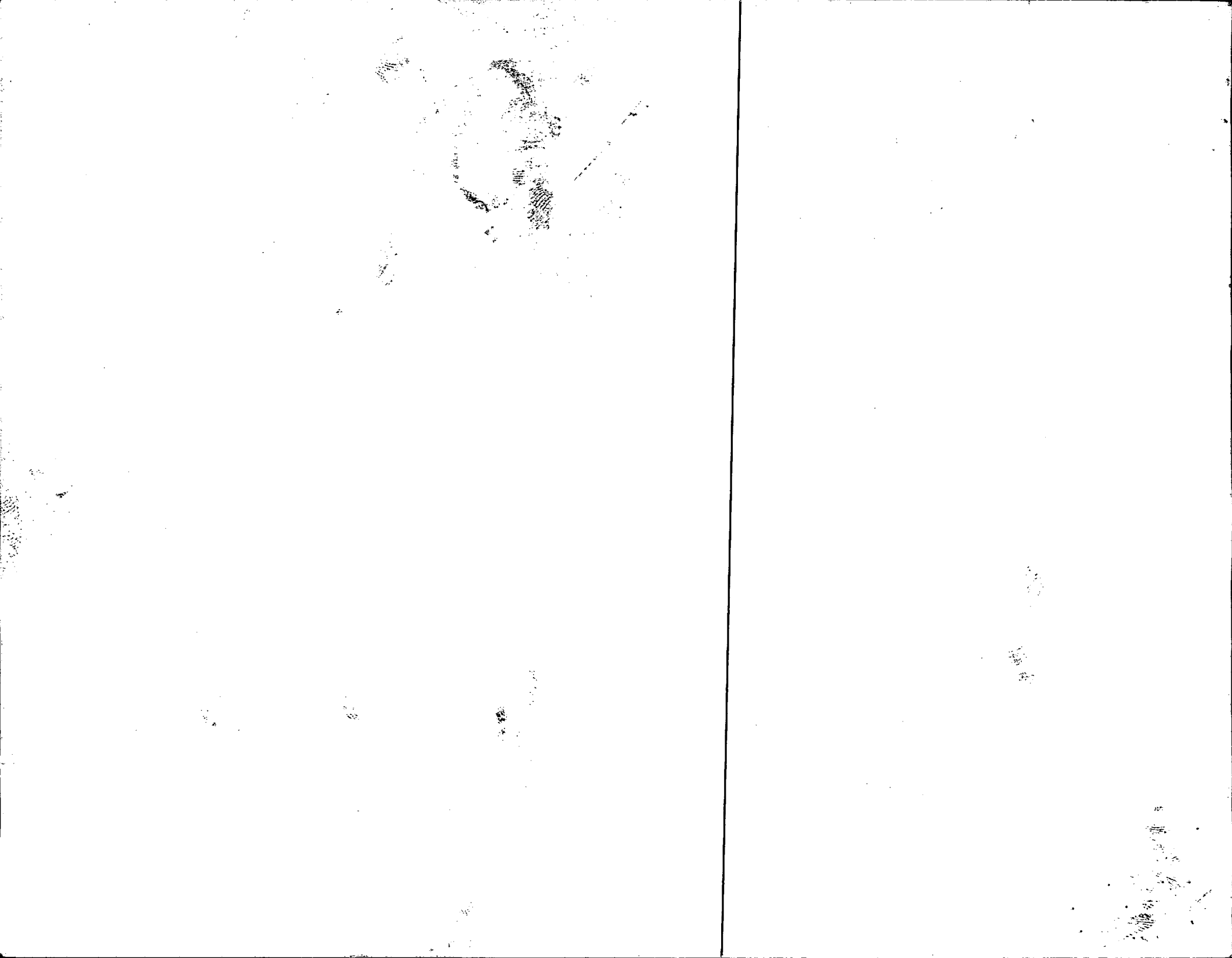
SHOP COPY  
RETURN TO  
ENGINEERING

#### GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) LENGTH OF D2500-1 EXTRUSION BEFORE BENDING = 189.5 INCHES \*
- 3) INSERT D2597 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) USE DART DRILL TEMPLATE TD2577-204 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (38 PLACES) AFTER FINISH. INSTALL AN3-4A BOLTS AND AN960JD10L WASHERS WITH SIKAFLEX-241.
- 6) WELDING TO BE DONE PER DART QSI 004.
- 7) FINISH:  
ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2597 WEB  
POWDER COAT ASSEMBLY GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
- 8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (10 PLACES).

UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE

WORK ORDER  
29959A



[illegible]

Technical drawing of a bolted joint assembly. The drawing shows a cross-section of a cylindrical component with a bolt and nut. The bolt is labeled "AN3-4A BOLT (1)" and "WASHER (1) (2 PLACES)". The nut is labeled "D2575 CAP". The bolt is secured with a "SEAL WITH SIKAFLEX-241". The drawing includes a dimension line indicating a distance of "0.40". The text "DRILL PRIOR TO D2575 CAP INSTALLATION (2 PLACES)" is also present.

Diagram illustrating the assembly of a pipe section, showing the following components and steps:

- D2579 SPACER
- D2597 WEB (REF)
- ALS7-1032-130 (REF) (TYP 38 PLACES)
- AFTER PERFORM
  1. CHA
  2. INS
  3. WEI
  4. C'B

5

AFTER DRILLING AND BENDING ASSEMBLY  
PERFORM THE FOLLOWING FOR #0.508 HOLES ONLY:

1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2579 SPACER (17 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. C-BORE D2579 SPACER TO  $\phi 0.437$  X 1.00 DEEP

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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 299594  
9-9

37.50  
DISTANCE TO AFT END  
OF D2596 WEB  
3  
7  
1.750  
1.750  
#0.508 (TYP.)  
(34 PLACES)  
REFER TO DETAIL A  
8.750  
17.375  
26.000  
35.000  
36.000 (REF)  
4 EQUAL SPACES  
9.00 PITCH  
38.0  
71.000  
169.5  
(D2500-1)

**D2577-041 ASSEMBLY DETAIL**

WELD AS PER DETAIL B

BLACK ANTI-SKID TOP OF STEP TO 0.5 ABOVE BOTTOM EDGE

BLACK ANTI-SKID TO 0.5 ABOVE LOCATION RIDGE

0.5

1.5

1.5

D

P

P

P

P

1.5

1.5

REFER TO DETAIL C

D2577-3

D2577-7

D2577-1

AN3-4A BOLT (1)  
AN960J10L WASHER (1)  
(38 PLACES)

8

RELEASED  
98/09/17 BS

OF COPY ISSUED

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NO. 83

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name Barclay Elliott  
Joint Welding Procedure Tig  
Part number and Job number D204635041 / B29959 A

TEST WELDS REQUIRED

BASE METAL Alum WELDING PROCESS Tig  
Penetration Complete ☐ Partial ☒ Single Weld ☒ Double Weld ☐  
Current AC ☒ DC ☐ Backing YES ☐ NO ☒

	Position	Vertical	Down <input type="checkbox"/>	Up <input type="checkbox"/>
Sheet Groove	1G <input type="checkbox"/>	2G <input checked="" type="checkbox"/>	3G <input checked="" type="checkbox"/>	4G <input type="checkbox"/>
Tube Groove	1G <input type="checkbox"/>	2G <input checked="" type="checkbox"/>	5G <input checked="" type="checkbox"/>	6G <input type="checkbox"/>
Sheet Fillet	1F <input type="checkbox"/>	2F <input checked="" type="checkbox"/>	3F <input checked="" type="checkbox"/>	4F <input type="checkbox"/>
Tube Fillet	1F <input type="checkbox"/>	2F <input checked="" type="checkbox"/>	4F <input checked="" type="checkbox"/>	5F <input type="checkbox"/>

Crossbolt Spacer Welded into \_\_\_\_\_ Skidtube

TEST RESULTS

Visual Pass ☒ Fail ☐  
Penetration Pass ☒ Fail ☐  
Crossbolt Spacer Pass ☒ Fail ☐

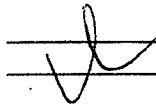
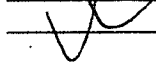
The above named individual is qualified in accordance with AWS D17.1.2001 to weld

Date of Test Coupon 06/12/22 Qualifier David Savel



Date: Tuesday, 28/08/2007 12:40:11 PM  
User: Linda Lacelle

# Process Sheet

Customer	: CC-DAR01 Dart Aerospace Ltd.	Drawing Name	: UPDATE PAPERW. 634/635
Job Number	: 34285		
Estimate Number	: 10804		
P.O. Number	: NIA	Part Number	: Z_CUSTOM
This Issue	: 28/08/2007 S.O. No. : NIA	Drawing Number	: ECN 1023
Prsht Rev.	: NC	Project Number	: NIA
First Issue	: NIA Type : LANDING GEAR	Drawing Revision	: NIA
Previous Run	: 00015	Material	: NIA
Written By	: 	Due Date	: 04/09/2007 Qty: 1 Um: Each
Checked & Approved By	: 		
Comment	:		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

REMOVE FROM STK / ADD NEW PAPERWORK  
EASA STC: EASA.IM.R.S.01303

B 32851, B 32854, B 32953, B 32951, B 32952, B 32212,  
D205-634-011 B 32613, 32618, B 32950, B 32615, B 32853, B 32213, B 32215

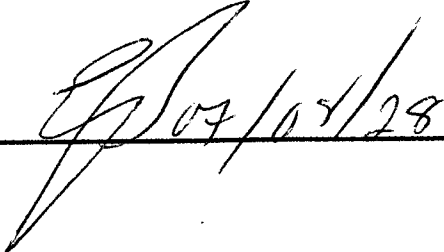
D205-634-041

D205-635-011 B 29278, B 29667, B 29955, B 29956, B 29957, B 29959

73 D205-635-041 B 21564, B 21821, B 22797, B 20000

D205-634-043

D205-634-045 B 12245  
D519372-011 B 33404  
RETURN TO STK

  
07/04/28

Date: Friday, 09/02/2007 9:59:35 AM  
 User: Linda Lacelle

## Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd.	Drawing Name : D205-635 / D204-635
Job Number : 30722	
Estimate Number : 10804	
P.O. Number : N/A	Part Number : Z-CUSTOM ECN952/908
This Issue : 09/02/2007 S.O. No. : N/A	Drawing Number : UPDATE PAPERWORK
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : OVERHEAD	Drawing Revision : N/A
Previous Run : 00015	Material : N/A
Written By : _____	Due Date : 16/02/2007 Qty: 1 Um: Each
Checked & Approved By : _____	
Comment : _____	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1  
 ADD NEW PAPERWORK TO KITS IN STOCK

TC STC SH96-88, ISSUE 3 / FAA STC SR00563N4

D205-634-011

D205-634-041

D205-634-043

D205-634-045

D204-635-011

D204-635-041

voir papier  
 avec ✓

7/4/27 SQ

2.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1  
 RETURN TO STOCK

7/4/27 SQ